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D3065-5

Job Sheet 201615



Part No: D3065-5

Job Qty: ⁸⁰180 pcs

DAS
21
9-89

Part Name: Step Leg



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Due Date: 5/28/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	160 pcs		5/27/20	0.02	14.75	Waterjet - Flow		<i>dc 20/02/16</i>
120	QC 8	160 pcs		5/27/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
125	Waterjet - Flow - B4B	160 pcs		5/27/20	0.00	2.67	Waterjet - Flow - B4B		

JUN 22 2020
DAS
40
9-89

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130	Handfinish - 1-1 Chemical-B4B	160 pcs	5/28/20	0.00 3.62	Handfinish - 1 - 1 - B4B	20.628
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	QC 7	160 pcs	5/28/20	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	

					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	AUG 26 2020
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
150	Packaging 3-1 - Stock - B4B	160 PCS	5/28/20	0.00 0.00	Packaging 3 - 1 - B4B	
		80 PCS MD			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 -	

DAS
40
9-89

DAS
28
9-89

AUG 26 2020

				B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	160 pcs	5/28/20	0.00 0.00	QC 21 - SA - 21	B4B
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 9-89

AUG 26 2020

Part Op 100 - 1-Cut as per Dwg
 Descriptions: 120 - QC8- Inspect parts - second check
 125 - ~~CHECK GRAIN DIRECTION~~ DEBURR ON DEBURRING MACHINE (no set-up time required)
 130 - Chemical Conversion Coat per QSI005 4.1
 140 - QC7-Inspect Chemical Conversion Coat
 150 - Identify as per dwg & Stock Location: _____ - LOCATION : GA
 160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	132 sf (.825 ea)	100-Waterjet - Flow - 1	5232779

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	132	333	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Log	16.458inches ± 0.010	16.468 16.448		
2	Step Log	15.750inches ± 0.005	15.755 15.745		
3	Step Log	2.250inches ± 0.005	2.255 2.245		
4	Step Log	3.460inches ± 0.005	3.465 3.455		
5	Step Log	0.865inches ± 0.005	0.870 0.860		
6	Step Log	6.020inches ± 0.005	6.025 6.015		
7	Step Log	1.205inches ± 0.005	1.210 1.200		
8	Step Log	3.484inches ± 0.005	3.489 3.479		
9	Step Log	0.871inches ± 0.005	0.876 0.866		
10	Step Log	8.325inches ± 0.010	8.335 8.315		
11	Step Log	0.551inches ± 0.010	0.561 0.541		
12	Step Log	0.213inches + 0.005 - 0.000	0.218 0.213		
13	Step Log	0.128inches + 0.005 - 0.000	0.133 0.128		

DART
AEROSPACE

Container No: S283122



Part: D3065-5

Job No: 201615

Serial No/Batch: S283122

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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